

6061-T6 R500"

BLUE

## Work Order ID 96853

\*96853\*

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February-07-13 11:23:31 AM

Item ID: D2651-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Plug

Start Date: 2/07/13 Start Qty: 120.00

\*120\*

Cust Item ID:

Required Date: 2/28/13 Req'd Qty: 120.00

\*120\*

Customer:

Reference:

Approvals:

Process Plan: 

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*


QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2651	Rev B								
100		0.00							
<b>*100*</b>	Hardinge CNC LATHE SMALL								
Hardinge	<b>Memo</b>	0.00							
Hardinge CNC Lathe Small	1- Turn as per Folio FA219 and Dwg D26512- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

13-02-10

120

0

13-02-10

120

0

B.A 13/02/11

120

0

EAS  
08  
2-89

# Work Order ID 96853

**\*96853\***

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February-07-13 11:23:31 AM

Item ID: D2651-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Plug  
 Start Date: 2/07/13 Start Qty: 120.00 **\*120\*** Cust Item ID:  
 Required Date: 2/28/13 Req'd Qty: 120.00 **\*120\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
155	Spray Painting per QSI005 4.2	0.00							
<b>*155*</b>									
SprayPaint	Memo	0.00							
Spray Painting	PRIME B <u>117319</u> DELFLEET BLUE B <u>121722</u> DELFLEET CLEAR B <u>118093</u>  START TIME: <u>6:00</u> FINISH TIME: <u>6:45</u>								
165	QC14- Inspect Spray Paint	0.00							
<b>*165*</b>									
QC	Memo	0.00							
Quality Control									

120 7613.214

120 0 0 13-2-17

120 DAS 03 13-02-20

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### Quality Control

# Picklist Print

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Page 1

Work Order ID: 96853

Parent Item: D2651-1

Parent Item Name: Plug

Start Date: 2/07/13

Required Date: 2/28/13

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP: A02.04.15New Issue NG  
IPP: B05.12.12added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	53.6860	0.0401	5.0652632 5.870'		2-13-02-10	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MAT012			53.686						
				114488			3.994						
				123483			12		5.870'				
				124029			37.692						



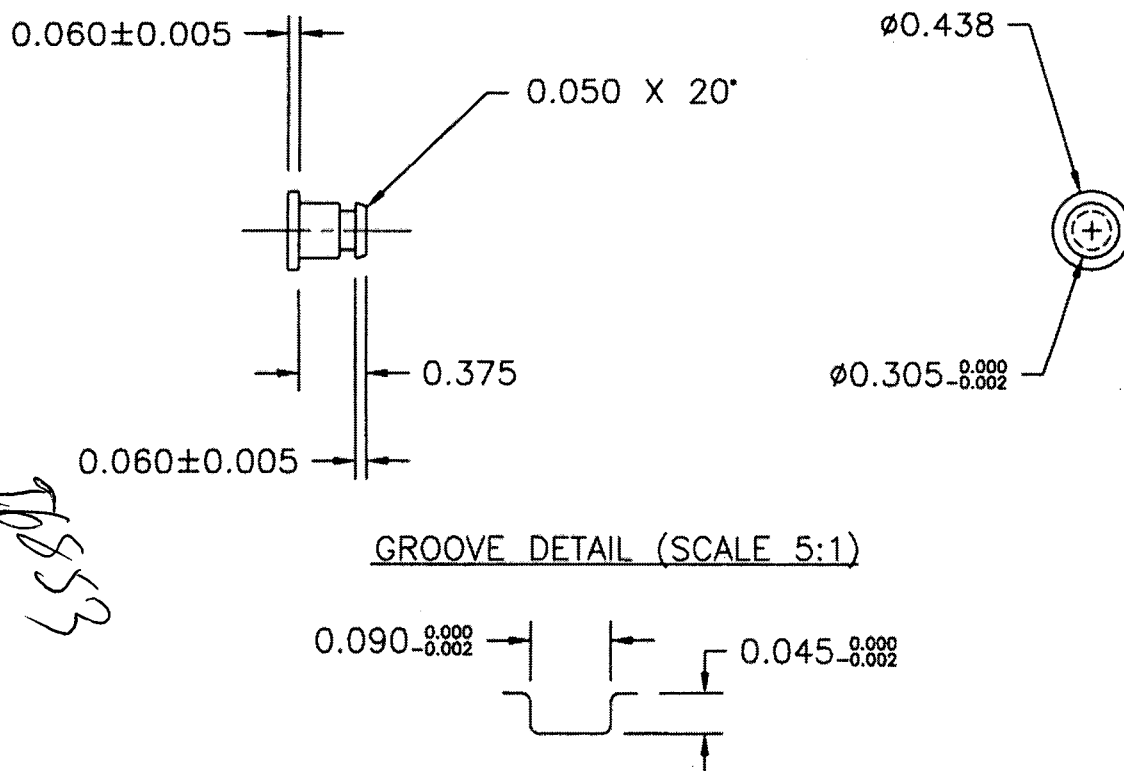


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19	TITLE PLUG		SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED

03.12.19

### D2651-1 PLUG:



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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